

Date: Wednesday, 18/06/2008 1:26:47 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 39922		Part Number	: D3121143	
Estimate Number	: 10279		Drawing Number	: D3121 REV E	
P.O. Number	:		Project Number	: N/A	
This Issue	: 18/06/2008	S.O. No.	Drawing Revision	: E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type	MACHINED PARTS		
Previous Run	: 39014		Due Date	: 11/07/2008	
Written By	:		Qty:	8 Um: Each	
Checked & Approved By	: <u>JWD 08.6.18</u>				
Comment	: Est Rev:Pick:A 04.02.18 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M174B1000X02000	17-4 SS Bar 
		
	Comment: Qty.: 0.3864 f(s)/Unit Total : 3.0912 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.000x02.000) Identify for D3121-113 Batch: <u>1108595</u>	<u>87 08/07/21</u>
2.0	BAND SAW	BAND SAW 
		
	Comment: BAND SAW Cut blanks: (1.000" x 2.000") 4.425" long	<u>87 08/07/21</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
		
	Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3121-113 as per Folio FA330 and Dwg D3121 Identify as D3121-113 2-Deburr 3-Scribe batch number	<u>87 08/07/21</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>85 08/07/28</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-143 PAR #: 08-024 Fault Category: Prod/Machined Parts NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/27	3.0	one part all the slot are off by .020" R.C Jig problem will remachine jig.	CP 08.07.28 pw QSI042	PAR 08-024 Re-manufacture Fixture Re-run hole & C'SINK to add 0.020" to top of holes	S.S 08/07/28 08/07/28 08/07/28	(S) 08/07/28	CP 08.07.28 pw QSI042	(S) 08/07/28
						(S) 08/07/28	MM 08.07.28	(S) 08/07/28

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:26:47 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 39922

Part Number: D3121143

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



JL 08/08/31

Comment: SECOND CHECK

6.0 D312121 Bolt



18

Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3121-21 Bolt

1339947 X 18

AS 08/08/01 (49)

7.0 D312124 Bearing Assembly



18

Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3121-241 Bearing Ass

39226 x12 40352 x6 AS 08/08/01

(49)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



(P2) →

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-143 as per Dwg D3121.

EDS/08/01 (9)

9.0 QC5 INSPECT WORK TO CURRENT STEP



S 08/08/01 (x8)

Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57233

ES/08/5 (9)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

AS 08/08/07

Job Completion



MF 08-08-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/01		Durlling Assembly of the D3121-21 Bolt Broke in hole. L.C. hole was not tapped all the way.	J QSLH	Drill out Broken bolt and re tap. Scrap and Replace bolt D3121-21 B& B39947	8/8/01 08/08/01	S 8/8/01	/	C 8/8/01
				Qty (fc)				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39922
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121	Rev: E	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.080	✓	-	-	
0.300	+/-0.010	.299	✓	-	-	
R0.375	+/-0.010	.375	✓	-	-	
1.54	+/-0.030	1.540	✓	-	-	
0.350	+/-0.010	.353	✓	-	-	
R0.25	+/-0.030	.250	✓	-	-	
Ø0.392	+0.002/-0.000	.393	✓	-	-	
Ø0.201	+0.005/-0.000	.206	✓	-	-	
2.540	+/-0.010	2.543	✓	-	-	
1.590	+/-0.010	1.593	✓	-	-	
0.160	+/-0.010	.162	✓	-	-	
0.400	+/-0.010	.400	✓	-	-	
1.220	+/-0.010	1.221	✓	-	-	
1.600	+/-0.010	1.605	✓	-	-	
3.80	+/-0.030	3.798	✓	-	-	
1.800	+/-0.010	1.803	✓	-	-	
R0.50	+/-0.030	.500	✓	-	-	
0.130	+/-0.010	.125	✓	-	-	
3.41	+/-0.030	3.400	✓	-	-	
3.65	+/-0.030	3.650	✓	-	-	
2.24	+/-0.030	2.220	✓	-	-	
45°	+/-0.1°	45°	✓	-	-	
R0.25	+/-0.030	.250	✓	-	-	
3.97	+/-0.030	3.971	✓	-	-	
R0.38	+/-0.030	.380	✓	-	-	
Ø0.392	+0.002/-0.000	.393	✓	-	-	
Ø0.201	+0.005/-0.000	.206	✓	-	-	
0.268	+/-0.010	.268	✓	-	-	
R0.260	+/-0.010	.260	✓	-	-	
0.080	+/-0.010	.078	✓	-	-	
0.300	+/-0.010	.297	✓	-	-	
0.381	+/-0.010	.381	✓	-	-	
0.201	+/-0.010	.204	✓	-	-	
0.580	+/-0.010	.580	✓	-	-	

DART AEROSPACE LTD	Work Order:	39922
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121 Rev: E		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

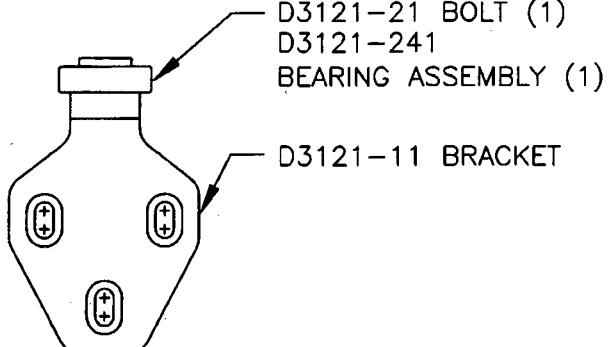
X First Article Prototype

Measured by:	J.S.	Audited by:	J.L.	Prototype Approval:	N/A
Date:	08/07/27	Date:	08/07/31	Date:	N/A

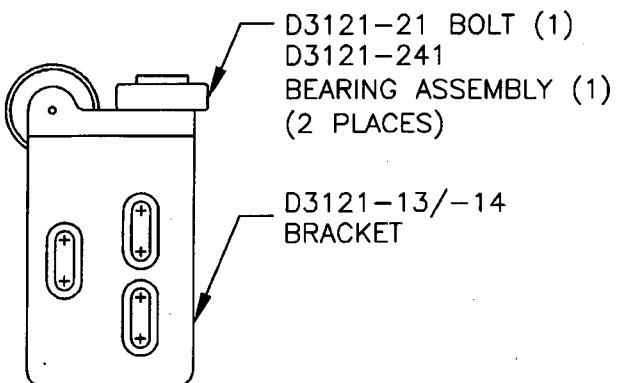
Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue P/O D3121-143	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	✓ ✓

DART

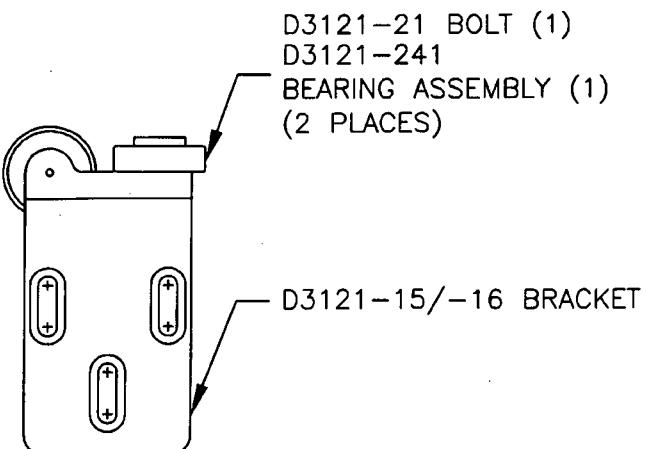
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

RELEASED
07.11.07**D3121-041 BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-33)

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-37/-38)

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-35/-36)

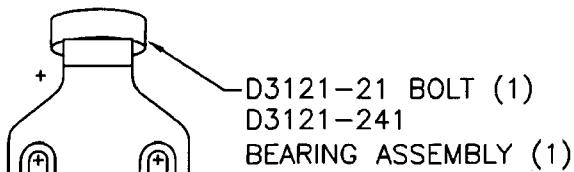
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

D3121-111 BRACKET

RELEASED
07.11.07 W

D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-03/-04)

D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-05/-06)

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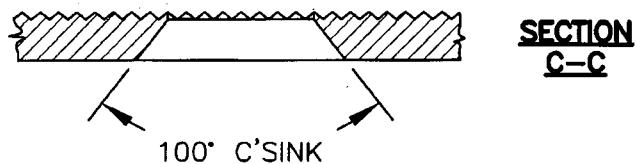
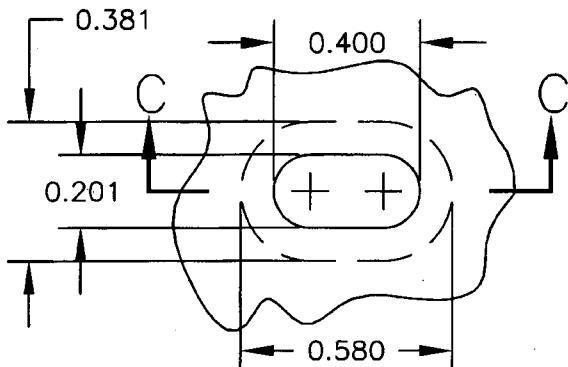
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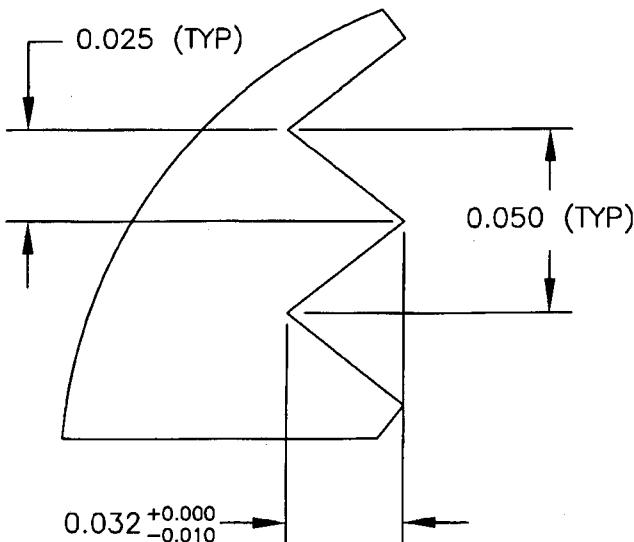
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



RELEASED
07.11.07 *[Signature]*

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



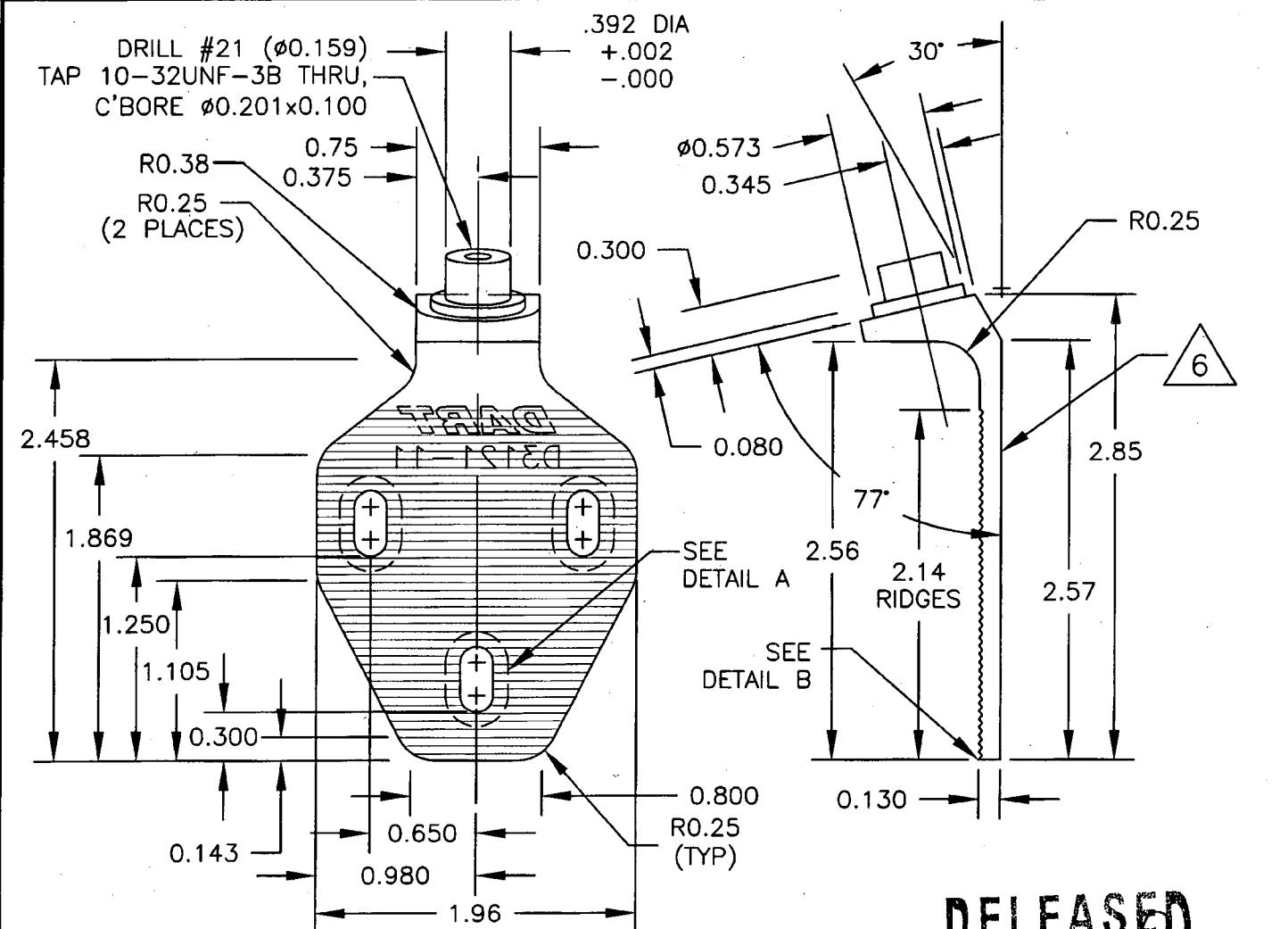
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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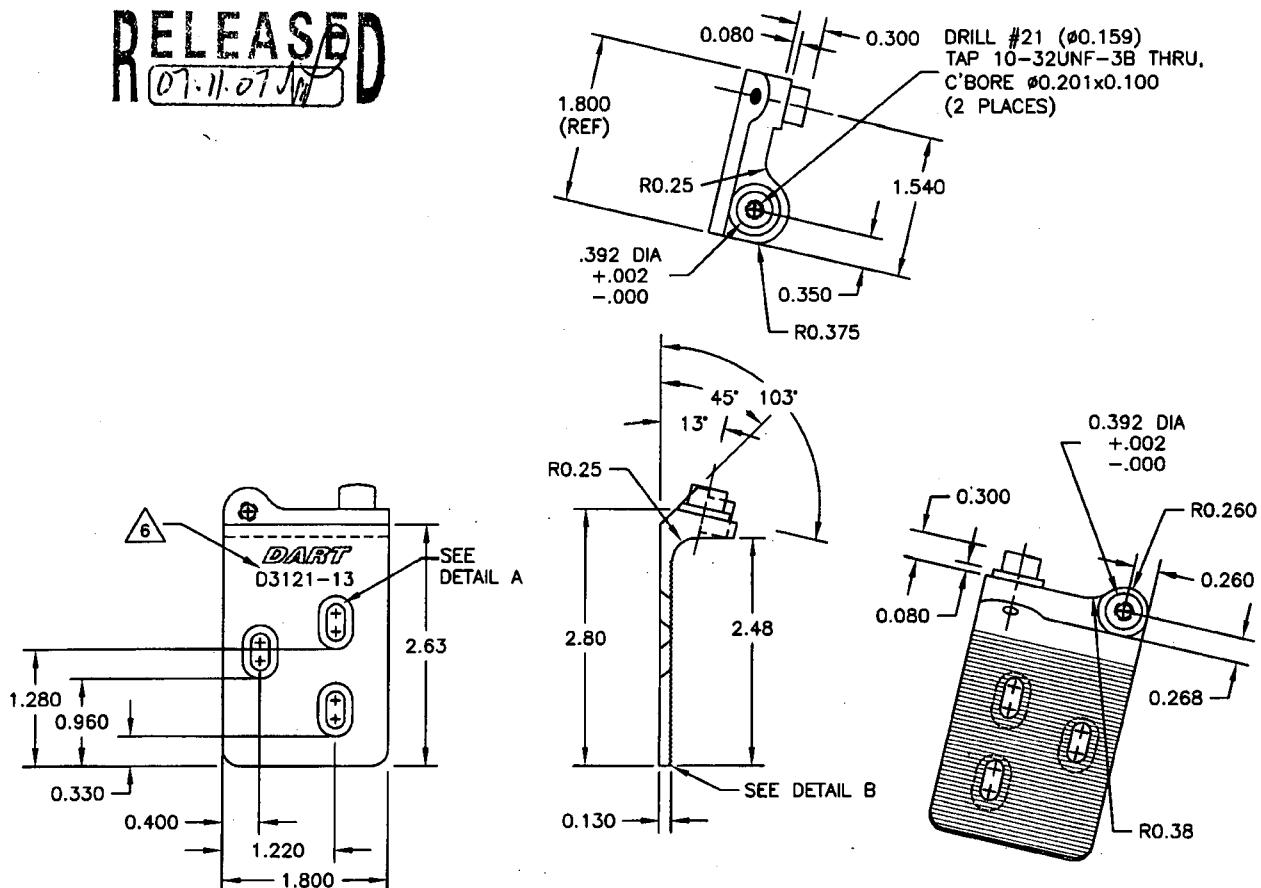
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

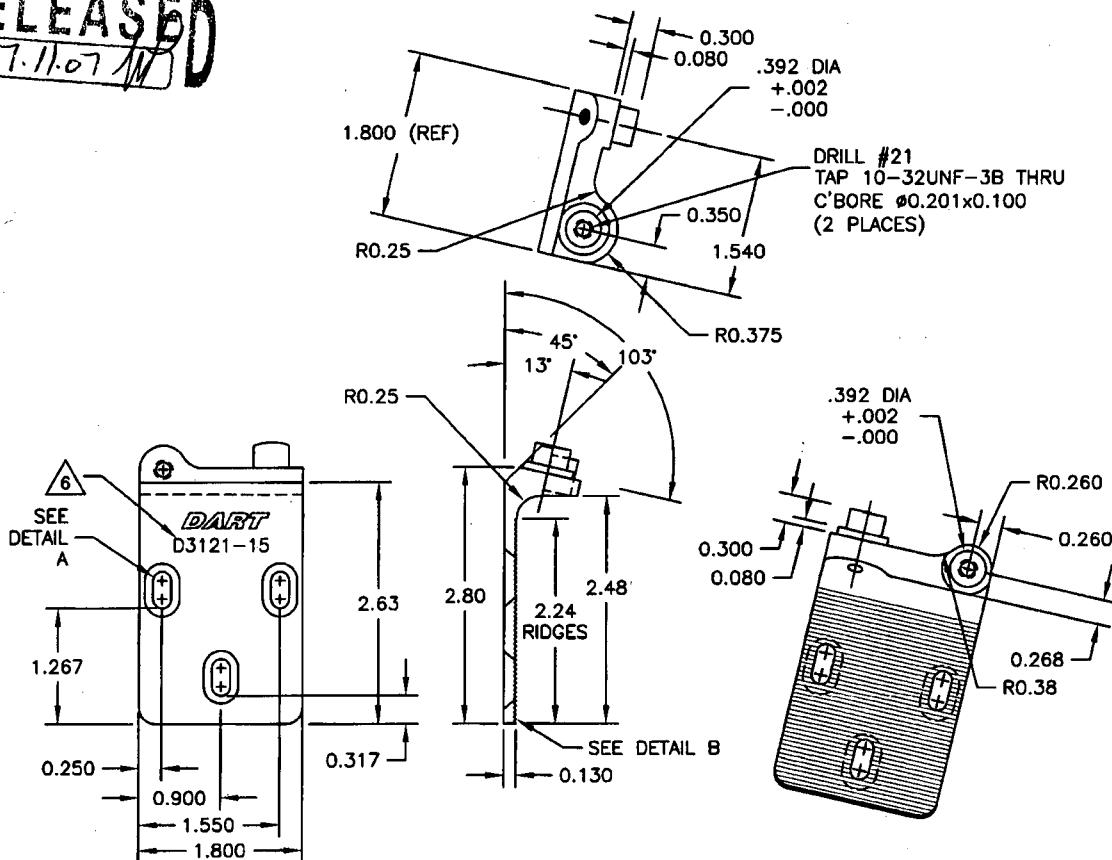
RELEASED
07.11.07**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) SHOP COPY
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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NO. 39922

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DATE	07.11.07	TITLE BRACKET ASSEMBLY SCALE 1:2

RELEASED
07.11.07

D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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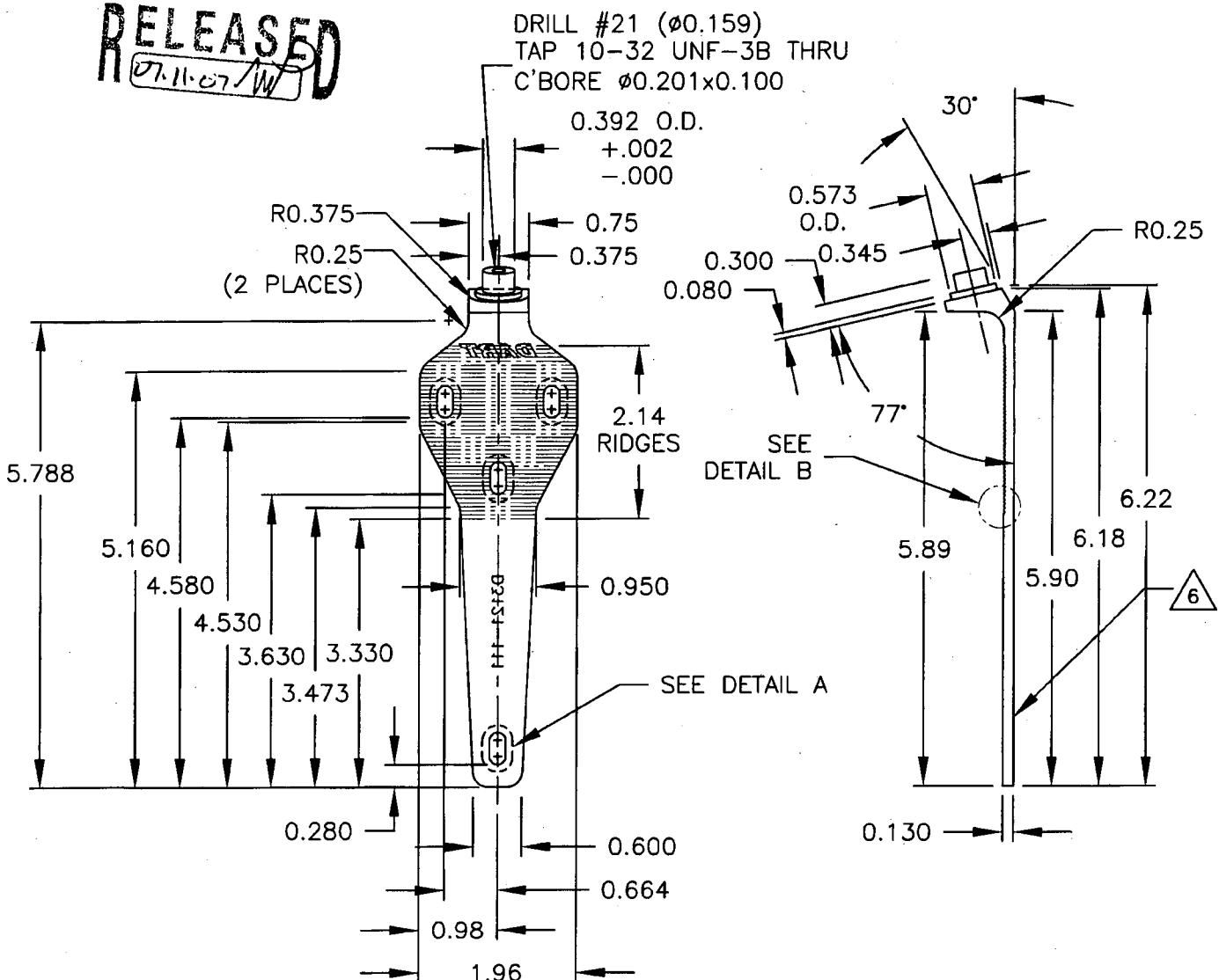
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CHECKED 	APPROVED 	DRAWING NO. D3121	REV. E	SHEET 7 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2	

RELEASED
07.11.07 W



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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WORK ORDER
3992

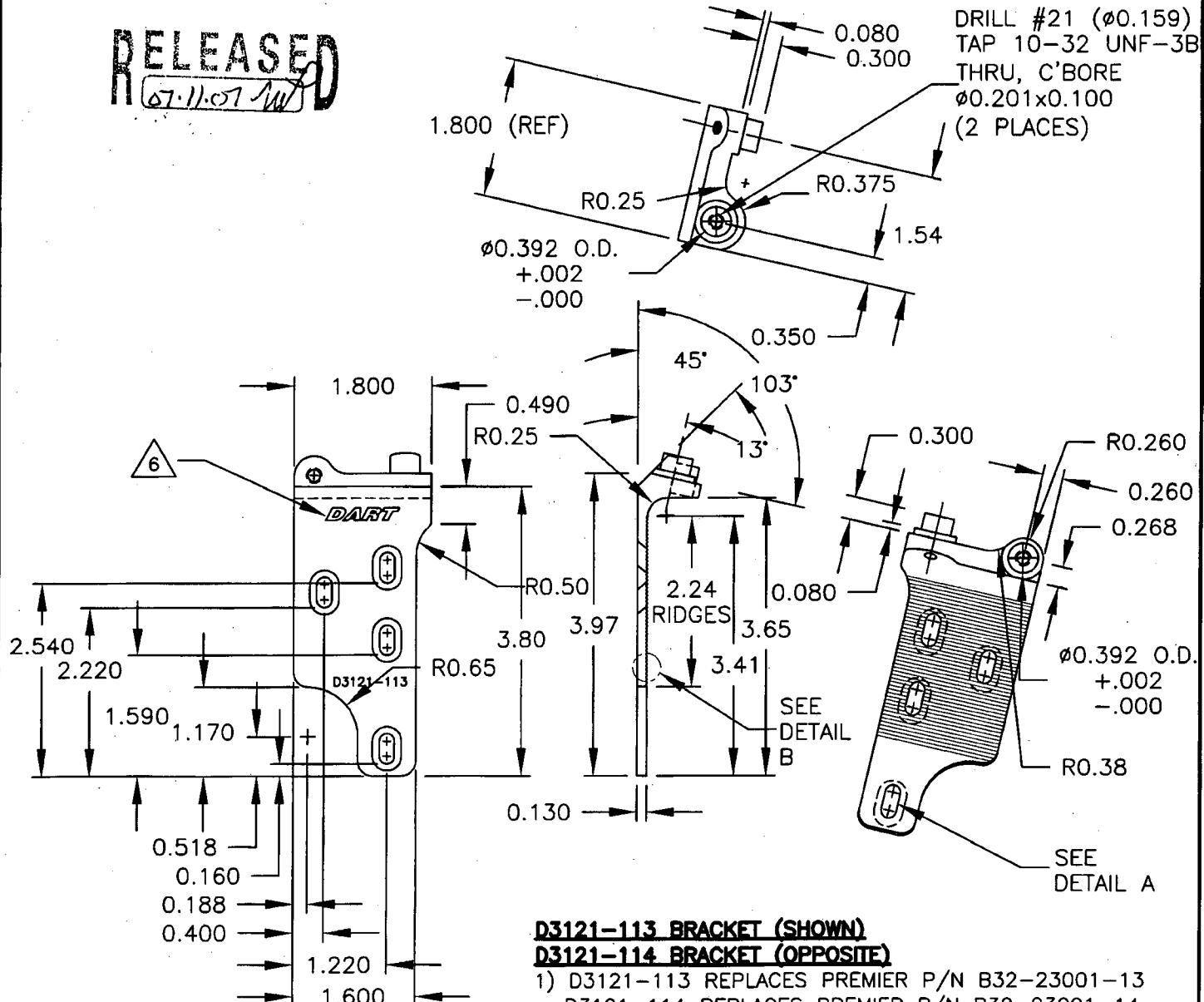
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DART

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CHECKED	APPROVED	DRAWING NO.	REV. E SHEET 8 OF 10
DATE	07.11.07	TITLE	SCALE 1:2

RELEASED
(07.11.07)**D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 3) SUBJECT TO AMENDMENT(S)
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

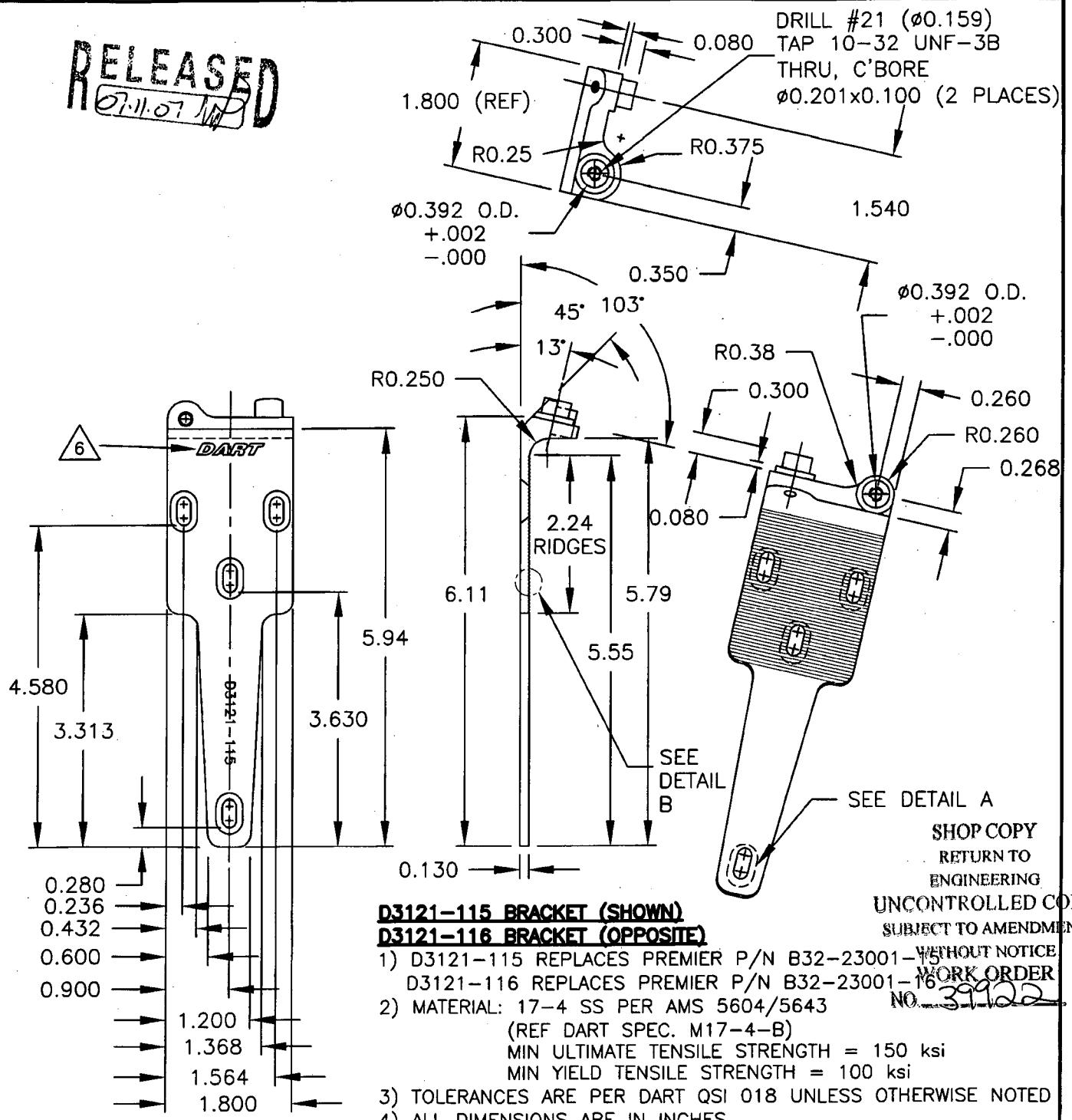
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CHECKED #	APPROVED <i>-</i>	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

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07.11.07



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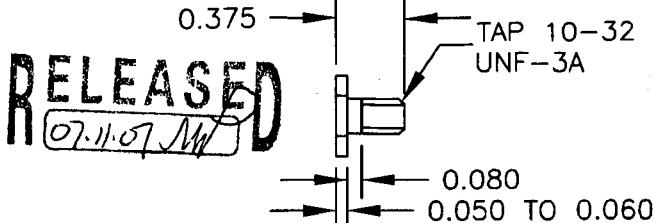
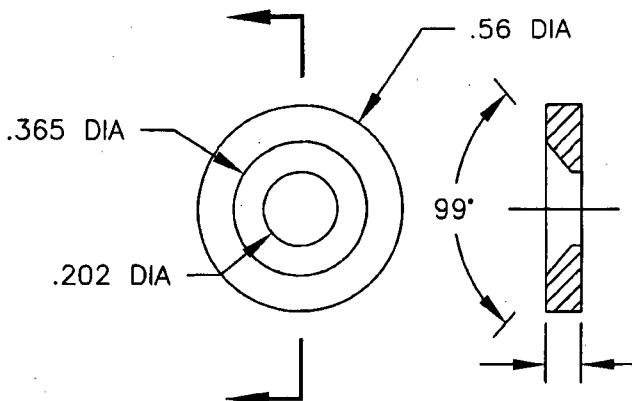
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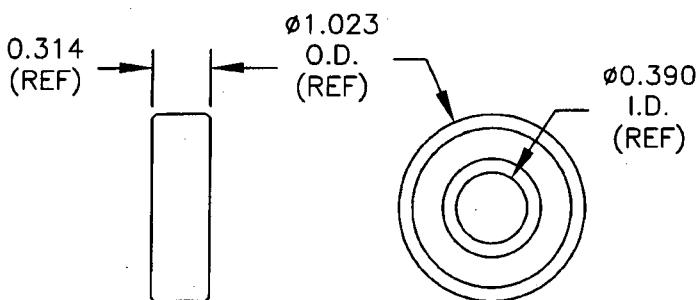
DART

DESIGN <i>AF</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AF</i>	APPROVED <i>HT</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



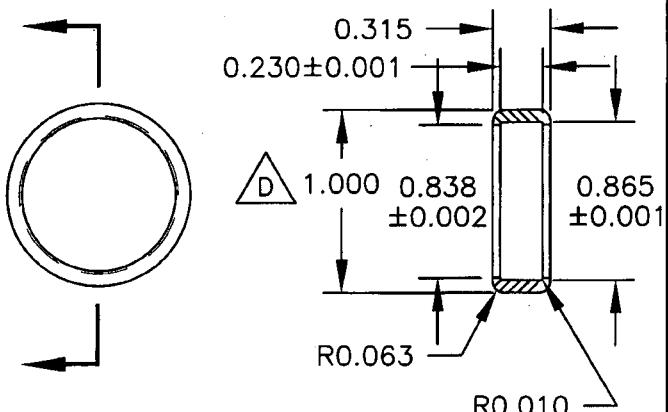
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



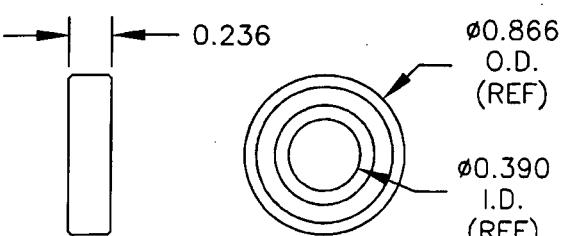
D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

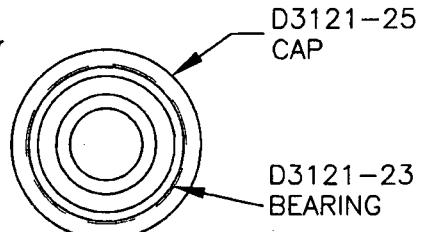
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

D3121-241 BEARING ASSEMBLY (SCALE 1:1)

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